

Date: Tuesday, 23/12/2008 12:53:24 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 A/B LOW GEAR WEB	
Job Number	: 44279		Part Number	: D26541	
Estimate Number	: 11768		Drawing Number	: D2654 REVE1	
P.O. Number	:		Project Number	: N/A	
This Issue	: 23/12/2008	S.O. No. :	Drawing Revision	: E1	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type	Due Date	: 05/01/2009	Qty: <i>100</i>
Previous Run	: 43445		Um:	Each	
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:E 08-06-10 revE1 as per dwg DD verified by:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-5 Web <i>B38589</i> <i>9-1-5 DP ①</i>		
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2654 (73.85") 2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends  <i>9-1-5</i>		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <i>S 09/01/05 (f)</i>		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <i>M/B 09-01-05</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206 A/B LOW GEAR WEB

Job Number: 44279

Part Number: D26541

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



9-1-06

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

Om^c 09-01-06

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
D09/01/06
MF 09-01-06

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

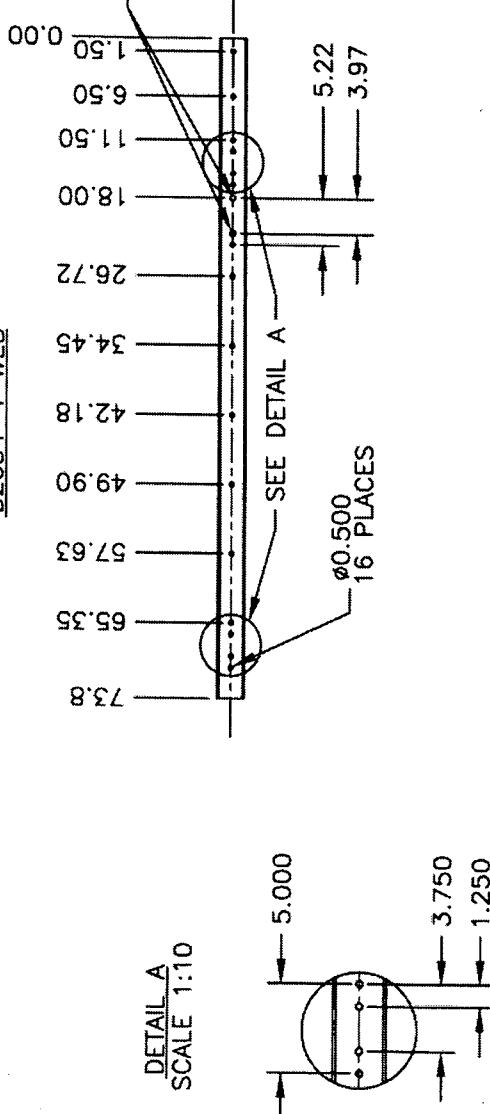


1 COPY ISSUED
03/07/97

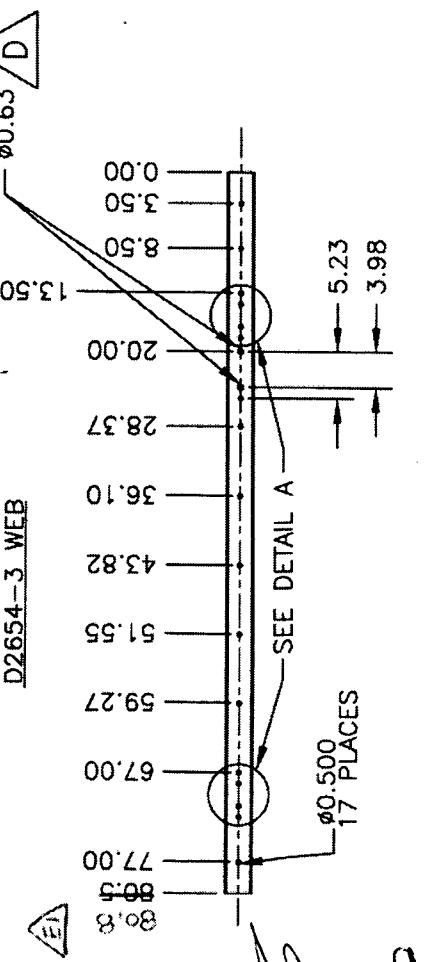
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E
		SHEET 1 OF 2
DATE 04.05.26	TITLE WEB	SCALE 1:20

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

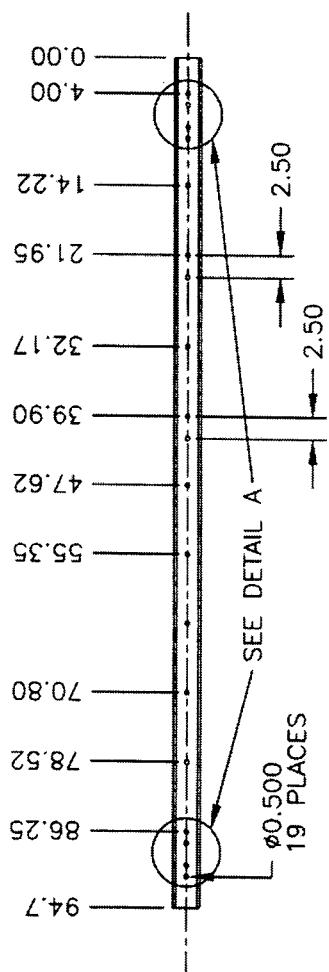
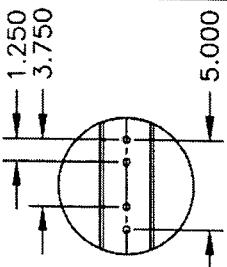
NOTE: Date & initial all entries

DARTCOPY
DRAFT

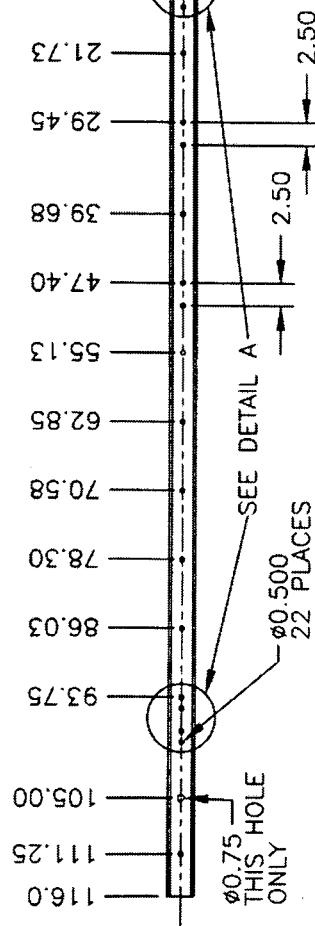
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654
DATE	04.05.26	REV. E SHEET 2 OF 2 TITLE WEB SCALE 1:20

RELEASED
04.05.26

D2654-5 WEB

DETAIL A
SCALE 1:10

D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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